

Work Order ID 66507

Thursday, February 17, 2011 10:55:10 AM

Page 1

Item ID: D4330-1
Revision ID: PRELIM
Item Name: Door Bracket

**PRELIMINARY
ISSUE**

Start Date: 2/17/2011 Start Qty: 2.00
Required Date: 2/18/2011 Req'd Qty: 2.00



Setup Start
Stop



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MIC Date: 11-02-17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4330	<u>PA1 PA2</u>

100 0.00



Waterjet FLOW WATER JET Memo 0.00

FLOW CNC Waterjet

6061 .050

1-Cut as per Dwg
Dwg Rev: PA1
Prog Rev: PA1
2-Deburr if necessary

11-2-17

(3)

110 0.00



QC QC2- Inspect parts off machine FAI/FAIB Memo 0.00

Quality Control

11-2-17

120 0.00



QC QC8- Inspect parts - second check Memo 0.00

Quality Control

-inspected to PA2

Dwg only
5/10/21/17

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66507

Thursday, February 17, 2011 10:55:11 AM



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Item ID: D4330-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Door Bracket

Stop



Start Date: 2/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Bend as per dwg
NC BRAKE

Memo

0.00

0.00

SP 11/02/17

(3)

Brake NC

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

inspected to P20
Dry only
8/10/21/7

(x3)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

3 p 11/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66507

Thursday, February 17, 2011 10:55:11 AM

Page 3

Item ID: D4330-1

Accept

Revision ID: PRELIM

Item Name: Door Bracket

Setup Start

Stop

Start Date: 2/17/2011 Start Qty: 2.00

Required Date: 2/18/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 11-02-22

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

sent to Harvey
at Eagle.

CY 11/02/22 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD1370
Feb10-2-22
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 17, 2011 10:55:07 AM

Page 1

Work Order ID: 66507



Parent Item: D4330-1



Parent Item Name: Door Bracket

Start Date: 2/17/2011

Required Date: 2/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.02.17 new issue DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

198.3900

0.0504

0.106105

5



B11-2-7

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT

166.8

114799

38.8

114993

128

MAT21

31.59

113216

31.59

113216

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66507
Description: DOOR BRACKET		Part Number: D4330-1
Inspection Dwg: D4330-1 Rev: PART A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.189	X		V BO2	
Ø .316	+ .006 - .001	.318	X		V	
.50	± .030	.502	X		V	
.88	± .030	.880	X		V	
1.25	± .030	1.257	X		V	
1.63	± .030	1.628	X		V	
2.00	± .030	2.003	X		V	
2.38	± .030	2.380	X		V	
3.06	± .030	3.006	X		V	
.38	± .030	.382	X		V	
.88	± .030	.883	X		V	
1.25	± .030	1.257	X		V	
1.92	± .030	1.927	X		V	
2.42	± .030	2.433	X		V	
1.06	± .030	.999	X		V	
1.50	± .030	1.498	X		V	
2.00	± .030	2.007	X		V	
.050	± .010	.050	X		V	

Measured by: MB	Audited by: S	Prototype Approval:
Date: 11-2-17	Date: 11/02/17	Date:

to PAB Dwg only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	


DART AEROSPACE LTD		Work Order:	66807
Description: Bracket		Part Number:	D4330-1 (Sent.)
Inspection Dwg: D4330	Rev: Part	Page 1 of 1	

Bent

☒ **First Article** ☐ **Prototype**

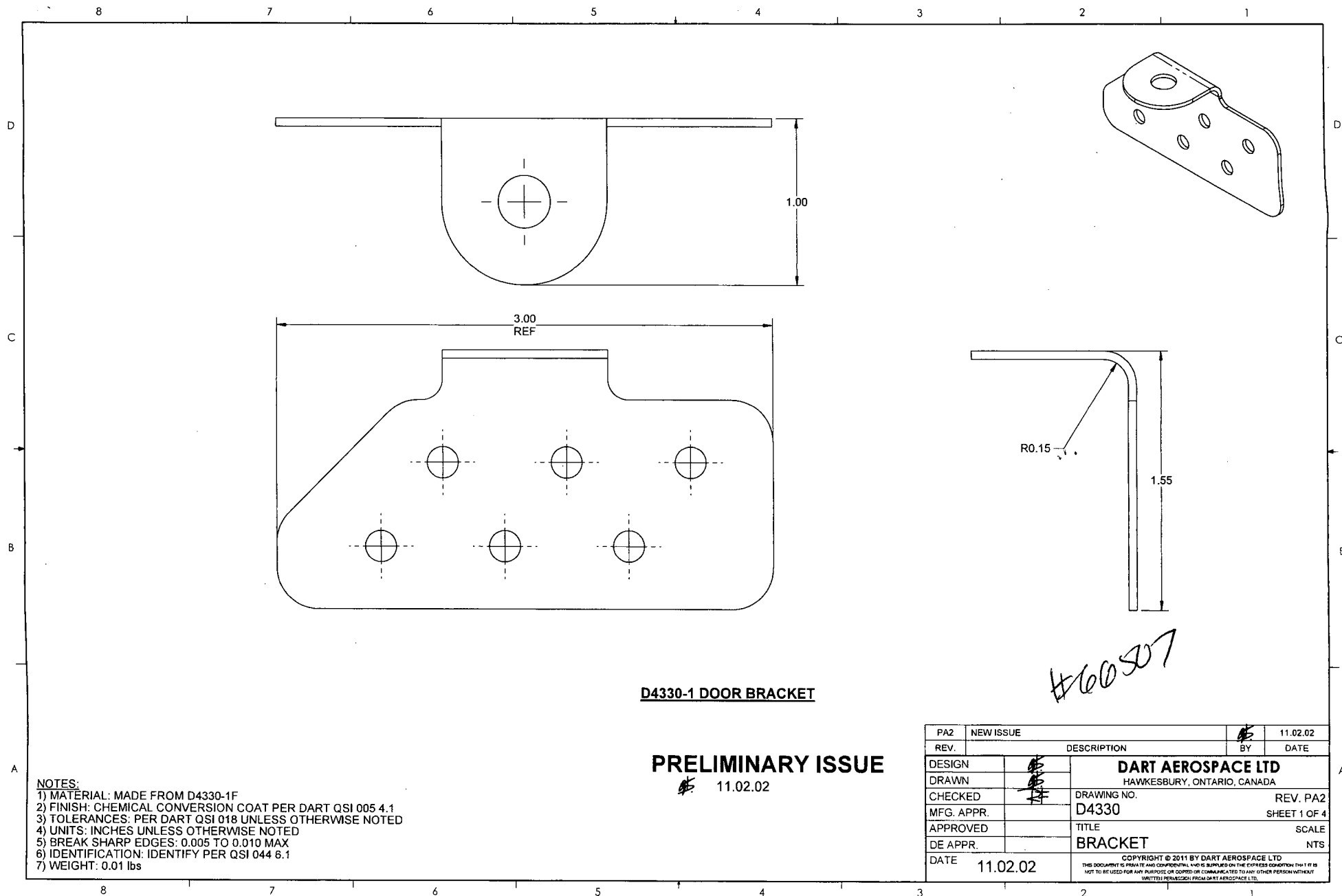
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Measured by:	SP 11/02/12
Date:	

Audited by:	
Date:	11/02/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4330-1 DOOR BRACKET

PRELIMINARY ISSUE

11.02.02

NOTES:

- 1) MATERIAL: MADE FROM D4330-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

PA2	NEW ISSUE		11.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4330** REV. PA2
SHEET 1 OF 4

TITLE **BRACKET** SCALE
NTS

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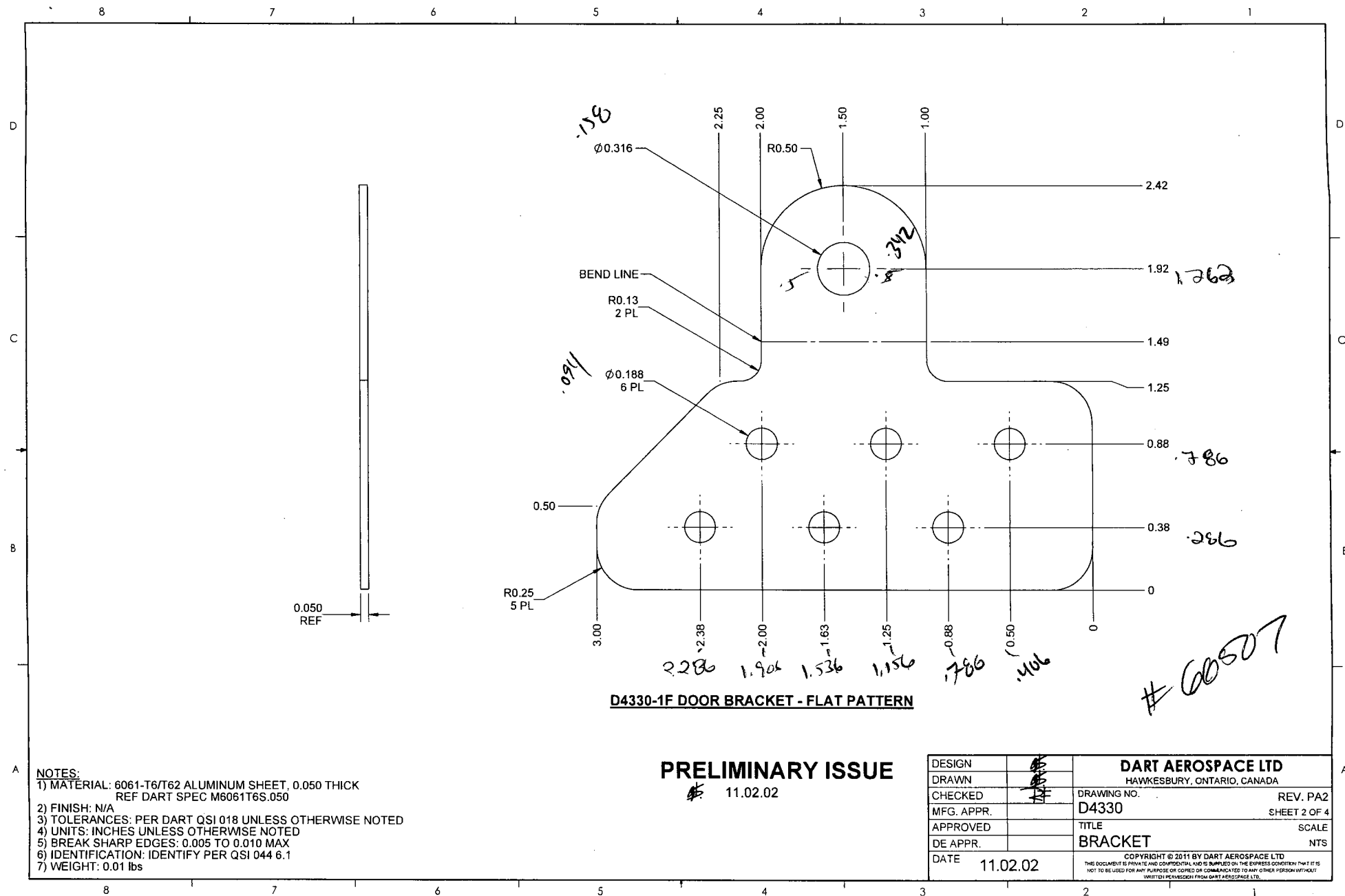
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____




Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



11.02.02

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4330	SHEET 2 OF
APPROVED		TITLE	SCALE
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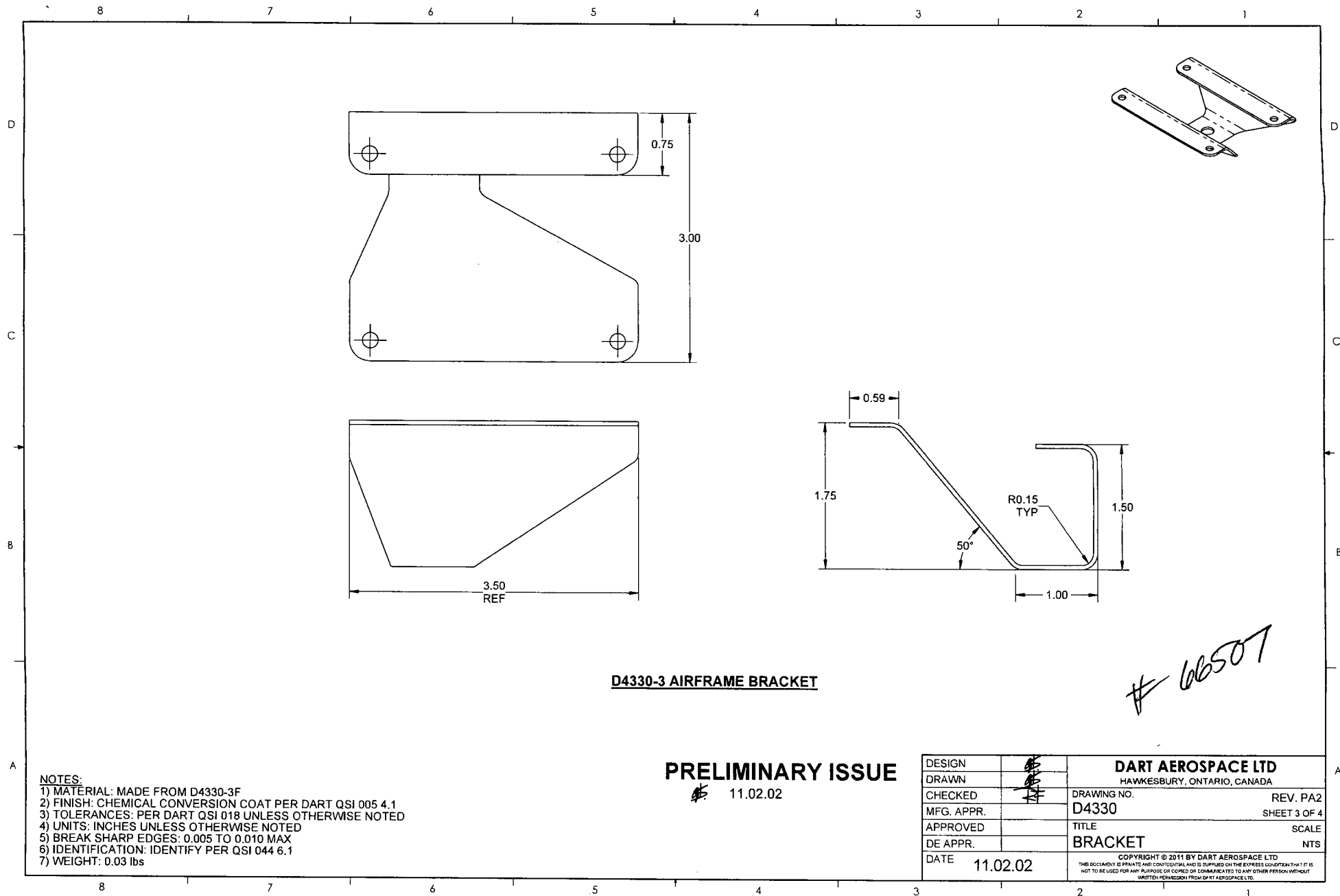
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4330-3 AIRFRAME BRACKET

PRELIMINARY ISSUE

11.02.02

NOTES:

- 1) MATERIAL: MADE FROM D4330-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

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66507

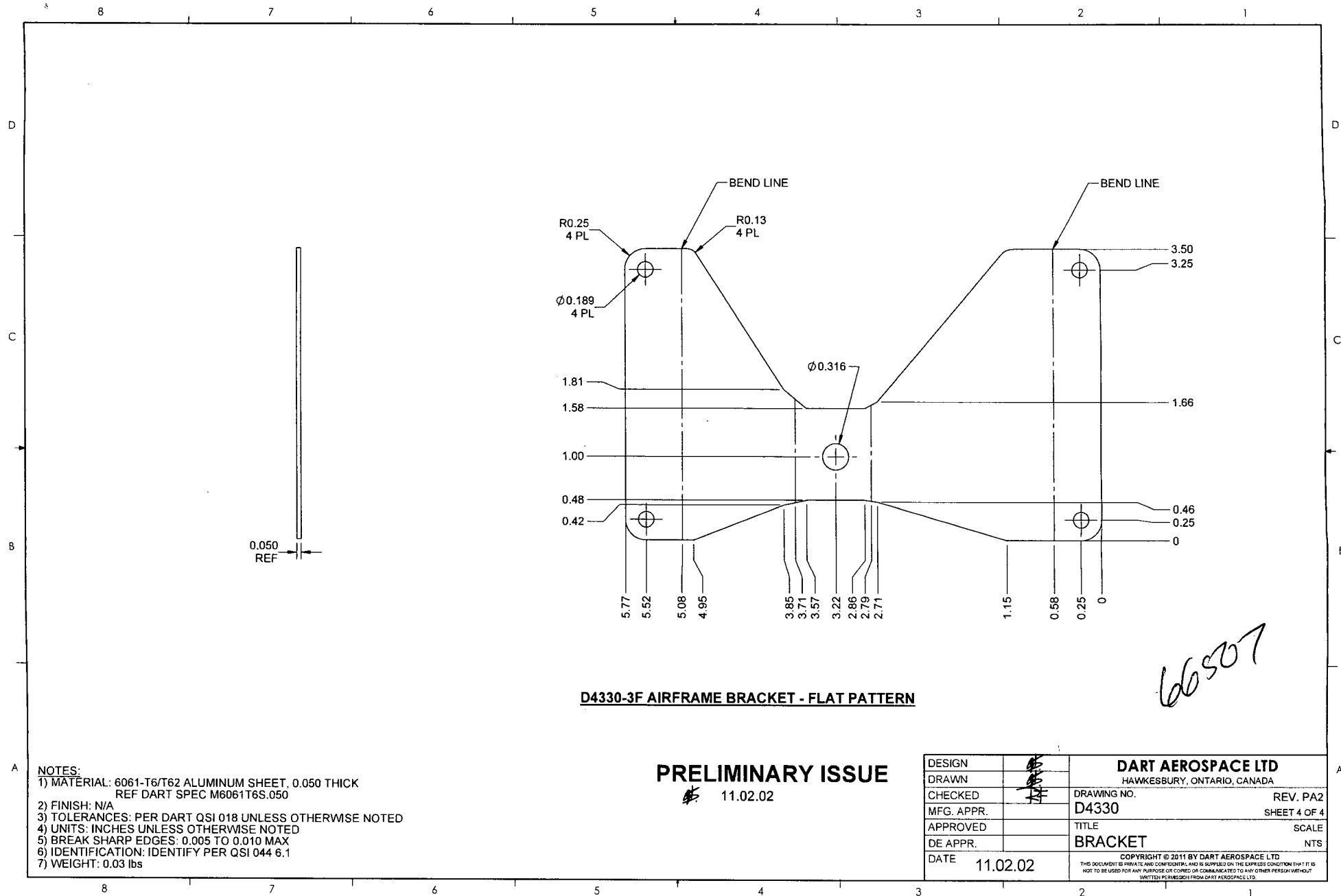
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC M6061T6S.050
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs

DESIGN	D4330	DART AEROSPACE LTD	
DRAWN	11	HAWKESBURY, ONTARIO, CANADA	
CHECKED	11	DRAWING NO. D4330	REV. PA2
MFG. APPR.			SHEET 4 OF 4
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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